

Date: Monday, 1/8/2007 11:06:22 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT		
Job Number	30182	Part Number	: K10003		
Estimate Number	10532	Drawing Number	: K10003		
P.O. Number	N/A	Project Number	: N/A		
This Issue	1/8/2007	S.O. No.	: N/A		
Prsht Rev.	NC	Type	: SMALL /MED FAB		
First Issue	N/A	Material	: N/A		
Previous Run	30052	Due Date	: 2/10/2007		
Written By	: <i>KA</i> <i>KA</i>				
Checked & Approved By	: <i>KA 07.01.08</i>				
Comment	Est: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels for D205-634-011 and D204-635-011 per PPP K10003 CHG005 <i>N/A 07.01.08 KA</i>			
2.0	D2570	Bushing	
Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 24 D2570 Bushing <i>B30198 ✓</i> <i>mf. 07-03-15</i>			
3.0	D2571	Saddle, Fwd, Out	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, Out Pick: Qty Part Number Description Batch 1 D2571 Saddle <i>B30012 ✓</i> <i>mf. 07-03-15</i>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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4.0	D2572	Saddle, Fwd, In
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, In Pick: Qty Part Number Description Batch 1 D2572 Saddle B20095 ✓ MF 07-03-15
5.0	D2573	Saddle, Aft, Out
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, Out Pick: Qty Part Number Description Batch 1 D2573 Saddle B29662 ✓ MF 07-03-15
6.0	D2574	Saddle, Aft, In
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, In Pick: Qty Part Number Description Batch 1 D2574 Saddle B29663 ✓ MF 07-03-15
7.0	D27361	Lug Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty Part Number Description Batch 1 D2736-1 Bracket B29783 ✓ MF 07-03-15
8.0	D27363	Lug Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty Part Number Description Batch 1 D2736-3 Bracket B29622 ✓ MF 07-03-15

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:	Machine Or Operation:	Description :	
9.0	D2747	Set Screw	
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s) Set Screw Pick: Qty Part Number Description Batch 4 D2747 Socket Head Set Screw B 30054, MF. 07-03-15</p>			
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Saddle Spacer Pick: Qty Part Number Description Batch 2 D2876 Spacer B 28016, MF. 07-03-15</p>			
11.0	D2877	Saddle Spacer	
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Saddle Spacer Pick: Qty Part Number Description Batch 2 D2877 Spacer B 24897 Lx10mx, B 28481 x 6mx MF. 07-03-14</p>			
12.0	D2968041	Tow Ring	
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tow Ring Pick: Qty Part Number Description Batch 1 D2968-041 Tow Ring B 27984 ✓ MF. 07-03-14</p>			
13.0	D35331	Set Screw	
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Set Screw Batch: B 28093 ✓ MF. 07-03-14</p>			

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
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Seq. #:	Machine Or Operation:	Description :
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14.0	AN46A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	m102959 ✓

MF. 07-03-14.

15.0	AN446A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	m102985 ✓

MF. 07-03-14

16.0	AN451A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	m102832 ✓

MF. 07-03-14

17.0	AN612A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	m102809 ✓

MF. 07-03-14

18.0	AN960JD416	Washer
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	m103338 ✓

MF. 07-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/19
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Machine Or Operation:

Description :

19.0 AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	m103829

✓ MF. 07-03-14

20.0 AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	m102929

✓ MF. 07-03-14

21.0 MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
29	MS21042L4	Nut (or MS21042-4)	m103349

✓ MF. 07-03-14

22.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

10/13/10 (8)

23.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Nev H

10/13/10 (8)

10/13/10 (8)

24.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/13/10 (8) 07/03/14

Job Completion



10/13/16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>44</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TT</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED06.11.13 *PH*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

NO. *30188*

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